

**ABSTRACT**

An object of the invention is to provide a laser machining method that can improve machining performance by promoting to remove debris generated during machining from the work piece. A work piece **2** that is transparent to an ultra-short pulse laser beam **L** is irradiated from one side of the work piece **2** (front surface **2a**) that faces the ultra-short pulse laser beam **L**. The irradiating ultra-short pulse laser beam **L** passes through the one side of the work piece **2** (front surface **2a**) and is focused on the other side (rear surface **2b**), and it machines the work piece **2** from or near a face (rear surface **2b**) at the other side.